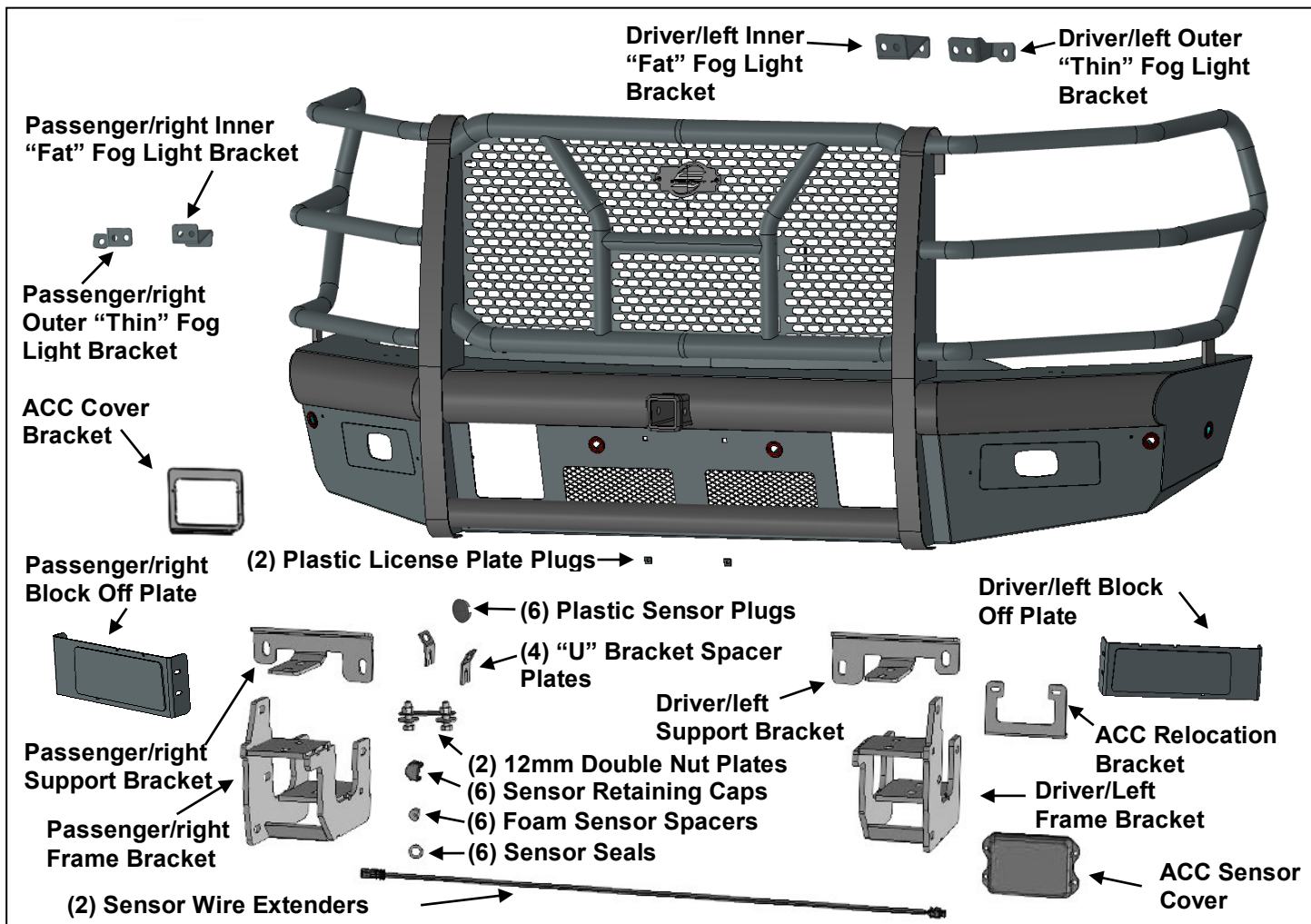


**STEELCRAFT HD REPLACEMENT FRONT BUMPER  
2024+ FORD F-150**

**PARTS LIST:**

1	HD Replacement Front Bumper	1	Sensor Cover Kit
1	Driver/Left Mounting Bracket	2	12mm x 170mm Hex Bolts
1	Passenger/Right Mounting Bracket	18	12mm x 45mm Hex Bolts
1	Driver/Left Support Bracket	36	12mm x 37mm OD x 3mm Flat Washers
1	Passenger/Right Support Bracket	4	12mm Lock Washers
1	Driver/Left Inner "Fat" Fog Light Bracket	16	12mm Nylon Lock Nuts
1	Driver/Left Outer "Thin" Fog Light Bracket	2	12mm Double Nut Plates
1	Passenger/Right Inner "Fat" Fog Light Bracket	18	6mm x 25mm Hex Bolts
1	Passenger/Right Outer "Thin" Fog Light Bracket	26	6mm x 18mm OD x 1.6mm Flat Washers
1	Driver/left Fog Light Block Off Plate	18	6mm Lock Washers
1	Passenger/right Fog Light Block Off Plate	8	6mm Hex Nuts
1	ACC Sensor Plastic Cover	2	6mm Flanged Nuts
1	ACC Sensor Cover Bracket	6	6mm x 12mm OD x 1.6mm Flat Washers
1	ACC Sensor Relocation Bracket	4	5mm x 16mm Button Head Bolts
4	Spacer Plate "U" Brackets	4	5mm Flanged Nuts
2	License Plate Plugs	12	4mm Self Tapping Screws
6	Plastic Sensor Plugs	2	Parking Sensor Wire Extenders
6	Sensor Retaining Caps	1	4mm Hex Wrench
6	15.5mm x 25mm OD x 2mm Foam Washers	1	3mm Hex Wrench
6	20mm x 10mm Foam Spacers		



**PROCEDURE:**

**REMOVE CONTENTS FROM PACKAGING. SOME PARTS ARE SMALL AND WILL BE HIDDEN IN WRAPPINGS. VERIFY ALL PARTS ARE PRESENT AND DO NOT DISCARD PACKAGING UNTIL INSTALLATION IS COMPLETE. READ INSTRUCTIONS CAREFULLY BEFORE STARTING INSTALLATION. BUMPER IS HEAVY, ASSISTANCE IS HIGHLY RECOMMENDED TO AVOID POSSIBLE INJURY OR DAMAGE TO THE VEHICLE.**

1. Remove the license plate and bracket if equipped.
2. From behind the front bumper, unplug and remove the active air dam from the bottom of the frame, **(Figures 1 & 2)**. It is not necessary to remove the lift motors, only remove the (6) bolts to remove the air dam. **NOTE:** Active air dam lift motor will not be installed or used on Steelcraft bumper. It will remain on OE bumper.
3. With the air dam out of the way, locate and unplug the main harness plug on the top of the passenger/right frame rail behind the bumper bracket, **(Figure 3)**. Unplug any remaining harnesses leading to the bumper. On hybrid models, temporarily remove the speaker assembly for the pedestrian audible alert system from the driver/left frame channel, **(Figure 4)**. Note speaker is located on the inner side of the frame, behind the driver/left bumper bracket. From below, remove the hex bolt and drop the speaker down, unplug and remove, **(Figure 5)**.
4. Place blocks or jack stands under the front bumper to support it during mounting hardware removal. Once the bumper has been safely supported, remove the large hex nuts from the back of each bumper bracket attaching the bumper to the bumper brackets, **(Figure 6)**. **WARNING!** Assistance is required to hold the bumper in place during hardware removal to prevent the bumper from falling. Carefully slide the bumper off over the tow hooks if equipped.
5. Remove both tow hooks if equipped, **(Figure 6)**.
6. **OPTIONAL:** On models with bolt-on frame extensions, remove the extensions from outside of frame, **(Figure 6)**. **NOTE:** It may be necessary to cut the bolts to remove frame extensions.
7. Models without tow hooks, insert (1) 12mm Double Nut Plate into the end of the driver/left side of the frame and over the two holes in the bottom of the frame, **(Figures 6 & 7)**.
8. Select the driver/left Frame Mounting Bracket. Attach the Bracket to the bottom of the frame and inner double nut plate with the included (2) 12mm x 45mm Hex Bolts, (2) 12mm Lock Washers and (2) 12mm Flat Washers, **(Figures 7 & 8)**. Do not fully tighten hardware at this time.
9. Next, insert (1) 12mm x 170mm Long Hex Bolt with (1) 12mm Flat Washer **through the inner side** of the Frame Bracket, and frame, **(Figure 9)**. **NOTE:** On models with ecoboost, it may be necessary to temporarily remove the hardware attaching the intercooler shutter assembly to insert the long Hex Bolt. Secure the Bracket to the frame with (1) 12mm Flat Washer and (1) 12mm Nylon Lock Nut.
10. Slide (2) "U" Bracket Spacers, (1 on inner, 1 on outer side of frame), down between the side of the frame and the inside of the Frame Bracket, **(Figure 9)**. once Hex Bolt has been installed. Do not fully tighten hardware.
11. Select the driver/left Frame Support Bracket. Attach the Bracket to the end of the frame with the included (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 10 & 12)**. Attach the Support Bracket to the top of the Frame Bracket with the included (2) 12mm x 45mm Hex Bolts, (4) 12mm Flat Washers and (2) 12mm Nylon Lock Nuts, **(Figures 11 & 13)**. **Models with tow hooks**, attach the tow hook to the inside of the Frame Bracket, **(Figure 12)**. **IMPORTANT:** Models with Adaptive Cruise Control (ACC) sensor, do not reinstall the driver/left side tow hook, **(Figure 13)**. Do not fully tighten hardware.
12. Repeat **Steps 8—11** to install the passenger/right Frame Bracket and Support Brackets, **(Figure 12)**.
13. Disassemble front bumper to unplug and remove fog lights, sensors and wiring harness from bumper. Pay attention to mounting location of all sensors for proper reinstallation.

14. On models with fog lights, determine the style of fog light.

**Models equipped with small halogen fog lights:**

- a. Attach the driver/left fog light assembly to the fog light mount tabs on the back of the Bumper with (3) 6mm x 25mm Hex Bolts, (3) 6mm x 12mm Flat Washers, and (3) 6mm Lock Washers (**Figure 14**). Repeat this step to the passenger/right fog light.
- b. Plug in the fog light harness to the lights and secure it to the Bumper.

**Models equipped with large LED fog lights:**

- a. Remove the hardware attaching the pre-installed driver/left small halogen fog light mounting bracket from behind the bumper, (**Figure 14**).
- b. Install the inner and outer Fog Light Bracket to the lower tabs underneath the fog light opening with (4) 6mm x 25mm Hex Bolts, (4) 6mm Lock Washers, (4) 6mm x 18mm Flat Washers, (**Figure 15**).
- c. Attach fog light to large LED mounting bracket with (3) 6mm x 25mm Hex Bolts, (6) 6mm x 18mm Flat Washers, (3) 6mm Lock Washers, and (3) 6mm Hex Nuts, (**Figure 16**). Repeat these Steps to attach the passenger/right fog light assembly.
- d. Plug in the fog light harness to the lights and secure it to the Bumper.

**Models without fog lights:**

- a. Remove the hardware attaching the pre-installed driver/left small halogen fog light mounting bracket from behind the bumper, (**Figure 14**). Set hardware aside for reuse.
- b. Select the driver/left Fog Light Block Off Plate.
- c. Reuse hardware removed from small halogen fog light mounting panel to attach Block Off to the same mounting tabs where the small halogen fog light panel was, (**Figure 17**)
- d. Repeat previous Steps to install the passenger/right Block Off.

15. Determine if the vehicle is equipped front sensors:

**Models without bumper sensors:**

- a. Select the included (6) Plastic Plugs.
- b. From the front, push the plugs into the sensor mounting holes, (**Figure 18**).

**Models with bumper mounted parking sensors:**

- a. Select the driver/left outer sensor. Remove the silicone seal from the end of the sensor. Slide the included larger Foam Sensor Seal over front of sensor, (**Figure 19**).
- b. Insert sensor with Seal into driver/left outer sensor mount, (**Figure 20**).
- c. Place Foam Spacer over end of sensor. Push Sensor Retaining Cap onto sensor mount and lock into mounting holes, (**Figure 20**).
- d. Repeat previous Steps to install remaining sensors.
- e. Install wiring harness for sensors. **NOTE:** Use the included (2) Wire Harness Extensions to extend the length of the factory harness to reach all sensors.

**Models with Adaptive Cruise Control (ACC). (If equipped, otherwise skip to Step 16)**

- a. Select the ACC Cover Bracket Attach the ACC Plastic Cover to the back of the Bracket with (4) 5mm Button Head Bolts, and (4) 5mm Flanged Nuts, (**Figure 21**).
- b. Remove sensor from outer steel OE bracket, (**Figure 22**).
- c. Attach the sensor to the back of the Relocation Bracket with (2) 6mm x 25mm Hex Bolts, (2) 6mm Lock Washers, (2) 6mm Flat Washers and (2) 6mm Flange Nuts, (**Figure 23**).
- d. Next, attach the sensor and Bracket to the tab on the back of the Bumper with the included (2) 6mm x 25mm Hex Bolts, (4) 6mm Flat Washers (2) 6mm Lock Washers and (2) 6mm Hex Nuts, (**Figure 24**). Fully tighten sensor mounting hardware.

16. With assistance, position the Bumper Assembly up to the outside of the Mounting Brackets, (**Figure 25**). Temporarily support the weight of the Bumper. **NOTE:** On models with EcoBoost, trim plastic shroud to fit Bumper profile as needed. **WARNING:** To avoid possible injury or damage to the vehicle, do not proceed until the bumper is fully and safely supported.

17. Attach the driver/left mounting plate on the back of the Bumper to the outside of the Mounting Bracket with the included (3) 12mm x 45mm Hex Bolts, (6) 12mm Flat Washers and (3) 12mm Nylon Lock Nuts,

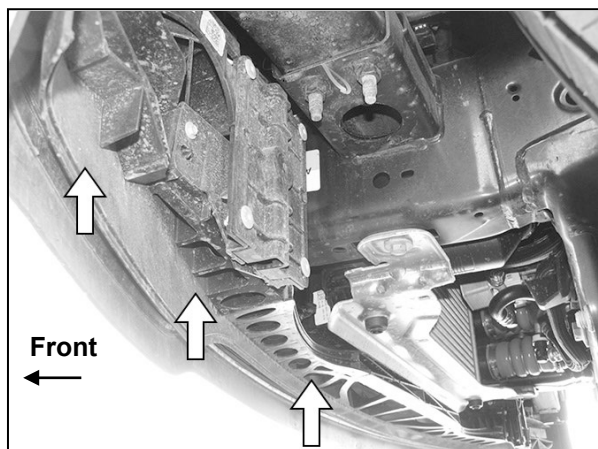
## STEELCRAFT HD REPLACEMENT FRONT BUMPER 2024+ FORD F-150

(Figures 25 & 26). Repeat this **Step** to attach the passenger/right side of the Bumper to the Bracket.  
Do not fully tighten hardware at this time.

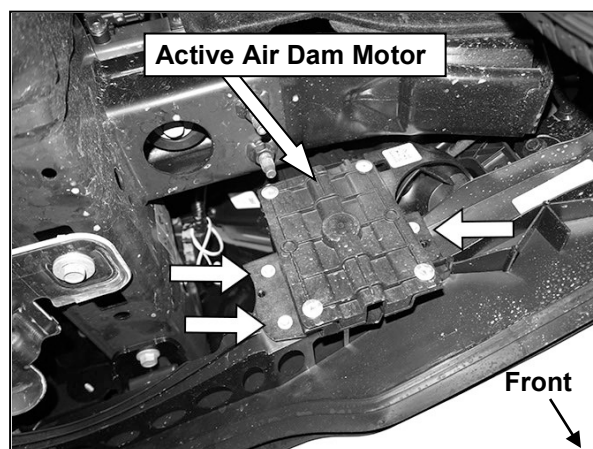
18. Level and adjust the bumper and fully tighten all hardware.
19. If front license plate is required, insert (2) Plastic Plugs into the square holes in the Bumper. Reuse the factory screws to attach the license plate to the Plastic Plugs, (Figure 27).
20. Models with grille mounted camera, remove screen from Bumper, (Figure 27).
21. Do periodic inspections to the installation to make sure that all hardware is secure and tight.

**To protect your investment**, Do not use any type of polish or wax that may contain abrasives that could damage the finish. Mild soap may be used to clean the Bumper assembly.

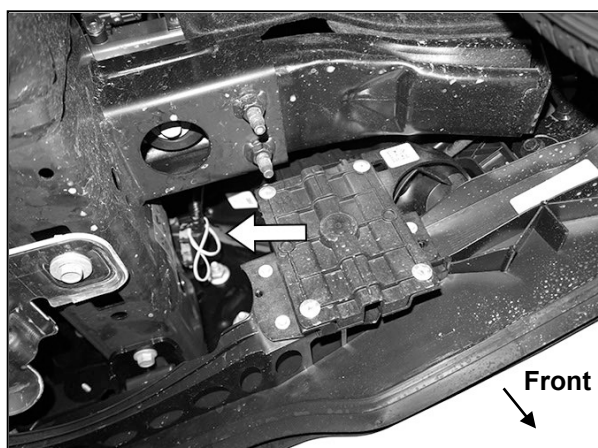
### Passenger/Right Side Installation Pictured



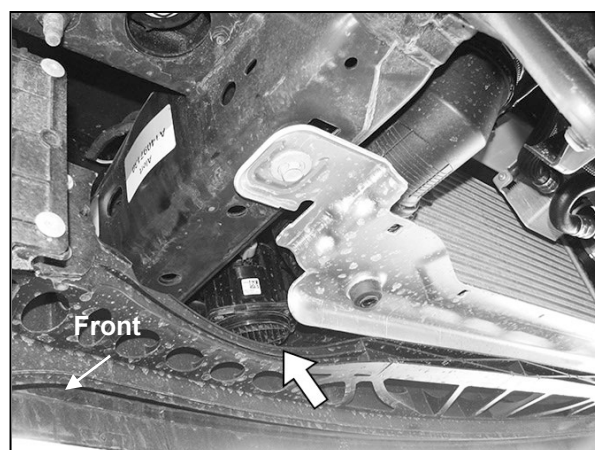
(Fig 1) Active air dam behind bumper



(Fig 2) Remove bolts (arrows) to remove active air dam from motors (passenger/right side pictured)  
NOTE: Air dam motor will NOT be installed on Steelcraft Bumper. Remains on OE bumper.



(Fig 3) Locate and unplug main harness plug on passenger/right side of bumper (arrow)



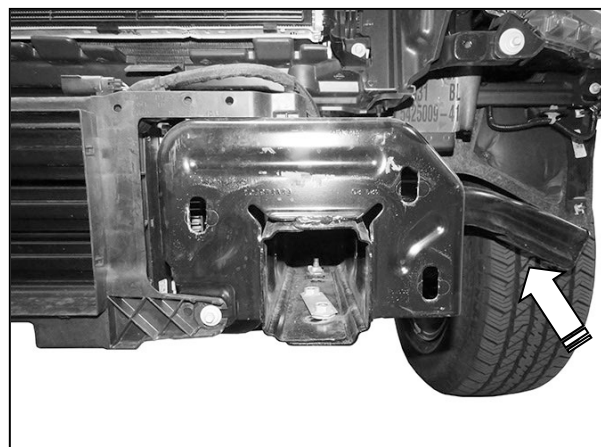
(Fig 4) Hybrid Models Only, locate alert speaker behind driver/left side of bumper

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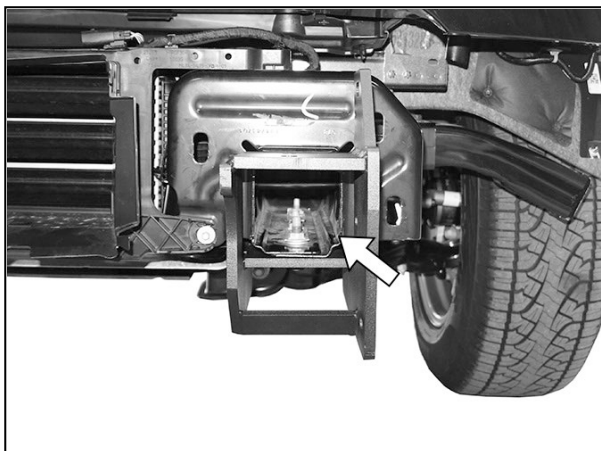
Driver/left Side Installation Pictured



(Fig 5) Remove bolt (arrow) to temporarily remove audible alert speaker located behind driver/left side of bumper (hybrid models only-pictured from below)



(Fig 6) Remove bumper and tow hooks. Also remove the factory frame extension (arrow-optional)

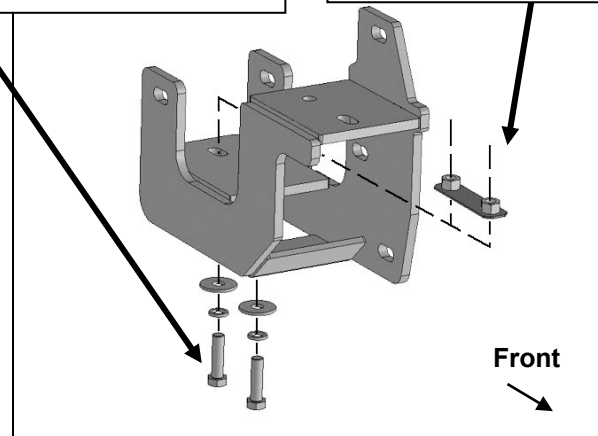


(Fig 8) Driver/left Frame Mounting Bracket attached to inner Double Nut Plate (arrow)

**WARNING!** Do not remove bumper bolts unless it is properly supported on blocks or stands or the bumper may fall.

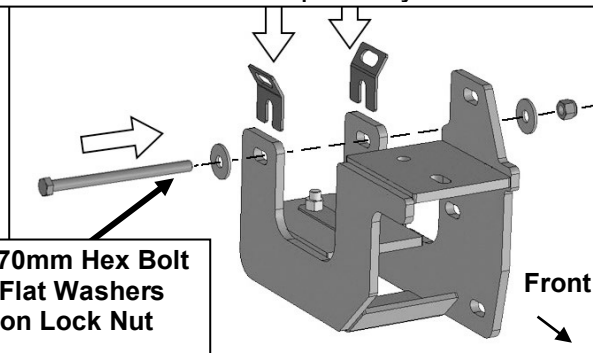
- (2) 12mm x 45mm Hex Bolts
- (2) 12mm Lock Washers
- (2) 12mm Flat Washers

Use either factory double nut plate or the included 12mm Double Nut Plate



(Fig 7) Attach driver/left Frame Mounting Bracket to end of frame

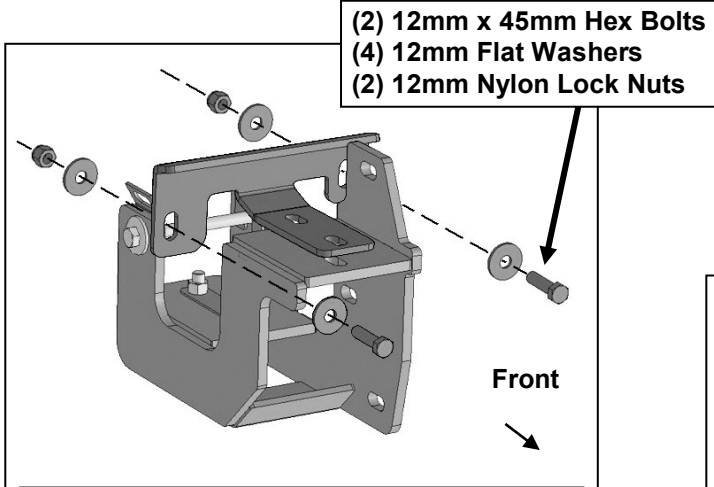
**WARNING!** Do not remove bumper bolts unless it is properly supported on blocks or stands or the bumper may fall.



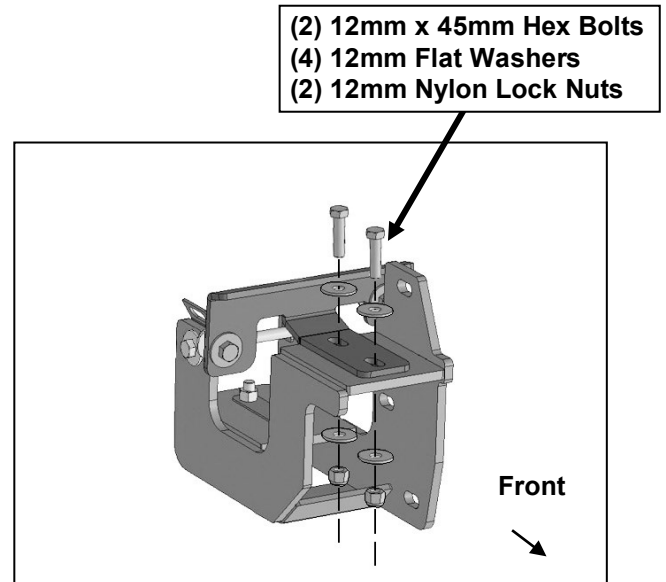
- 12mm x 170mm Hex Bolt
- (2) 12mm Flat Washers
- 12mm Nylon Lock Nut

(Fig 9) Insert "U" Bracket Spacers between side of frame and inside of Frame Bracket (driver/left side Bracket illustrated)

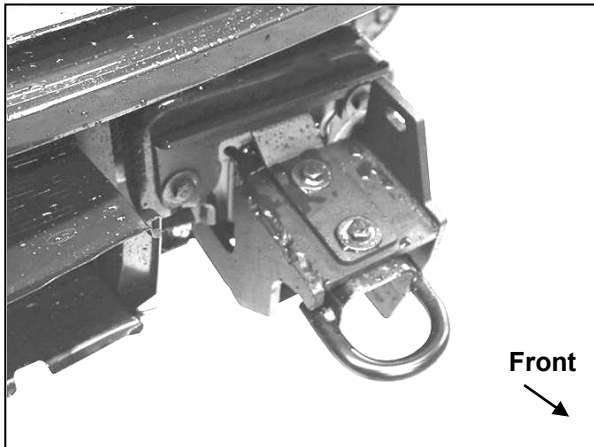
Driver/left Side Installation Pictured



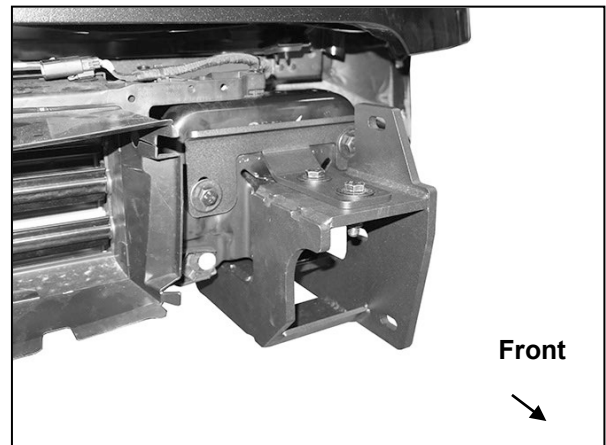
(Fig 10) Attach driver/left Support Bracket to top mounting holes in end of frame



(Fig 11) Attach driver/left Support Bracket to top Frame Bracket. Models equipped with tow hooks without ACC sensor, reinstall tow hook to inside of Frame Bracket



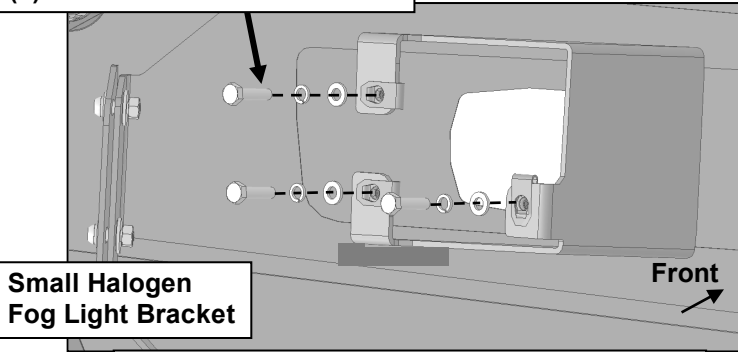
(Fig 12) Passenger/right Frame Bracket and Support Bracket installed with tow hook



(Fig 13) Driver/left Frame Bracket and Support Bracket installed. Models with ACC sensor, do not install driver/left side tow hook

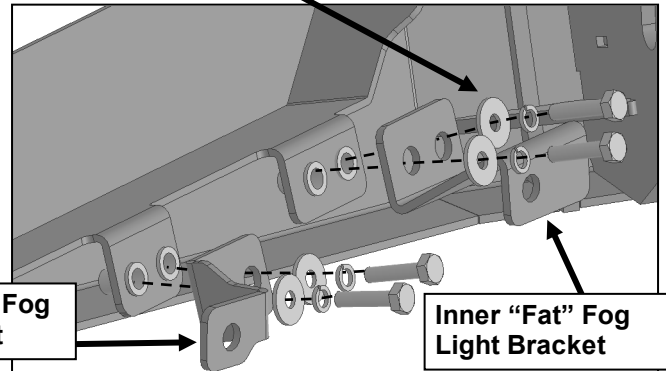
Driver/left Side Installation Pictured

- (3) 6mm x 25mm Hex Bolts
- (3) 6mm x 12mm Flat Washers
- (3) 6mm Lock Washers



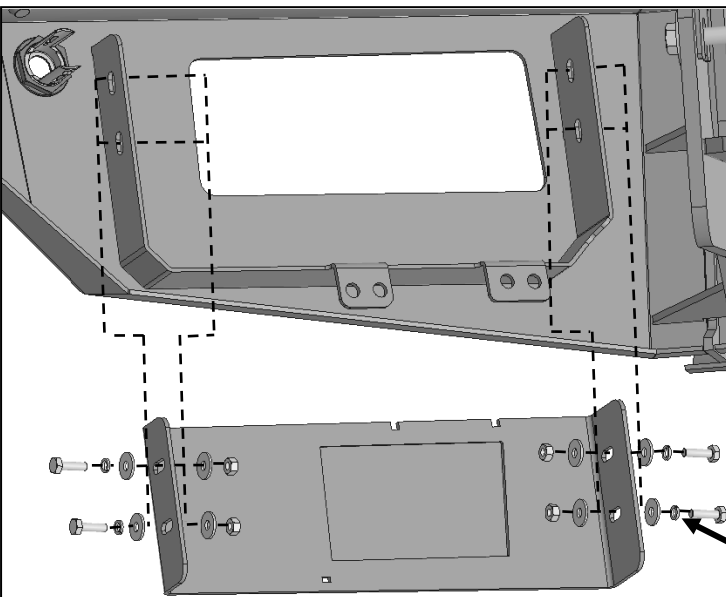
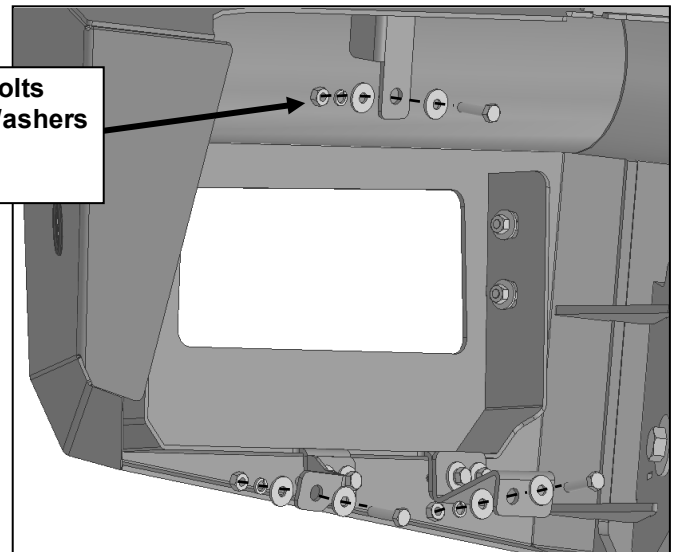
(Fig 14) Attach driver/left Halogen Fog Light assembly to tabs on Bumper.

- (4) 6mm x 25mm Hex Bolts
- (4) 6mm x 18mm Flat Washers
- (4) 6mm Lock Washers



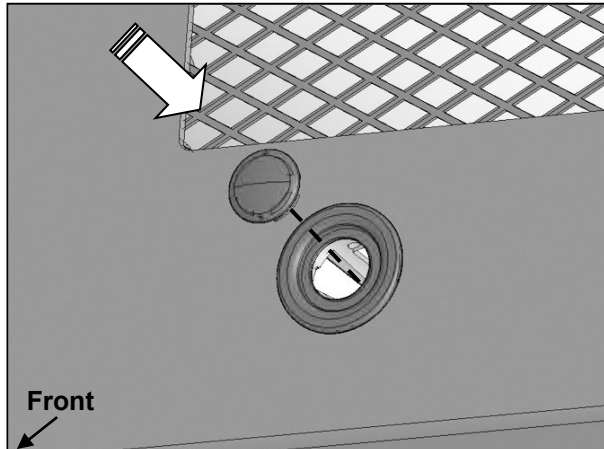
(Fig 15) Attach Inner and Outer Fog Light Bracket to tabs

- (3) 6mm x 25mm Hex Bolts
- (6) 6mm x 18mm Flat Washers
- (3) 6mm Lock Washers
- (3) 6mm Hex Nuts

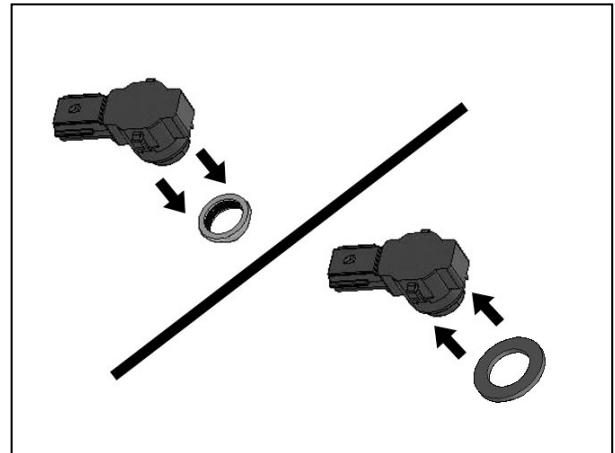


- Reuse Hardware
- (4) 6mm x 25mm Hex Bolts
  - (8) 6mm Flat Washers
  - (4) 6mm Lock Washers
  - (4) 6mm Hex Nuts

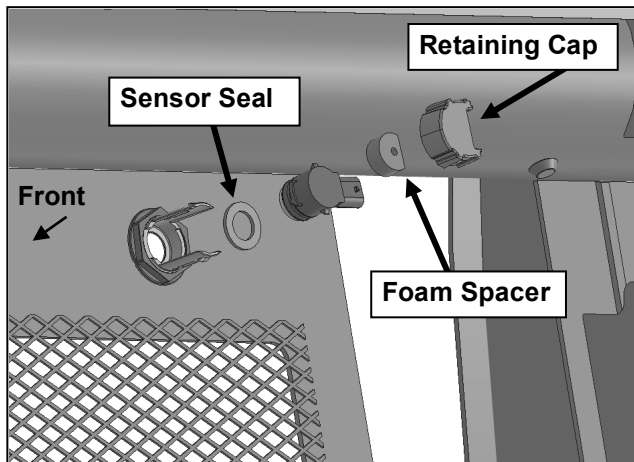
Driver/left Side Installation Pictured



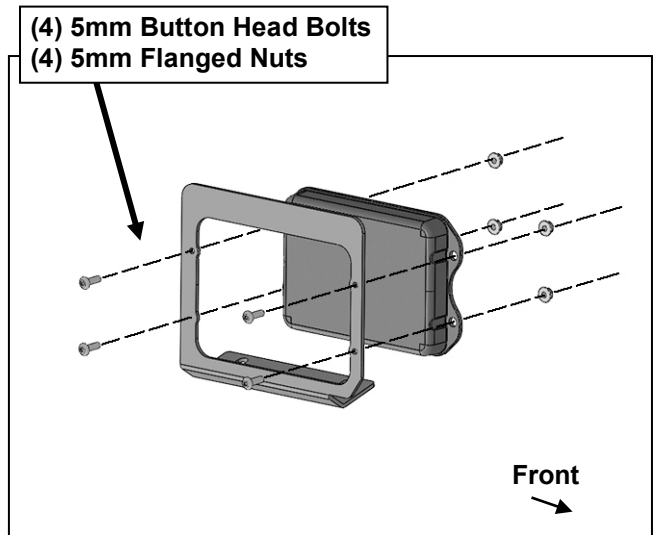
(Fig 18) Push Plastic Plug into sensor mount



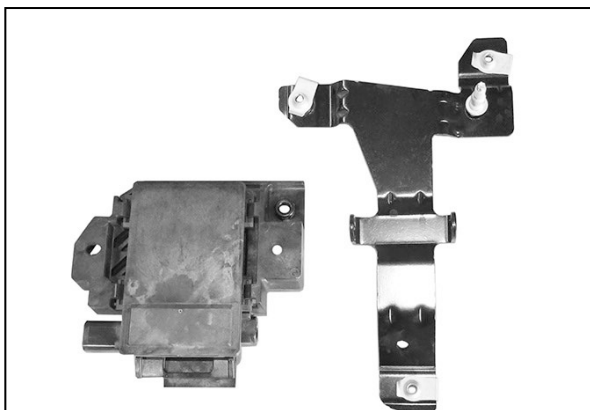
(Fig 19) Remove silicone seal from sensor. Slide large Seal over end of sensor (arrow)



(Fig 20) Insert sensor with Seal into the sensor mount on back of Bumper, followed by the Retaining Cap with Spacer



(Fig 21) Attach Plastic Cover to the ACC Cover Bracket

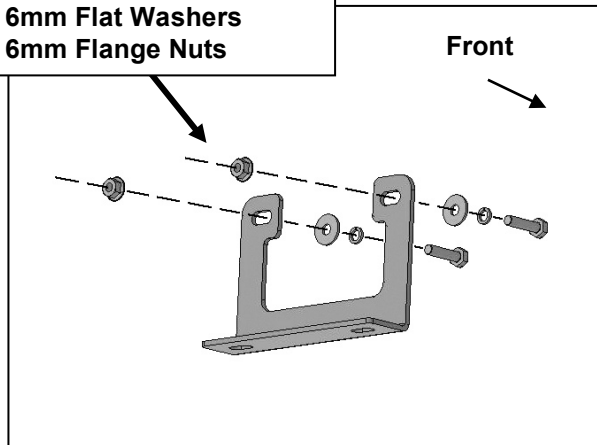


(Fig 22) Models equipped with ACC, remove sensor from OE mounting bracket



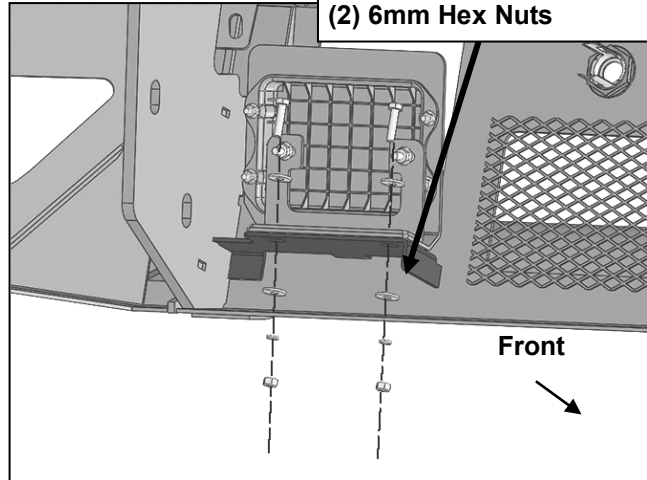
Driver/left Side Installation Pictured

- (2) 6mm x 25mm Hex Bolts
- (2) 6mm Lock Washers
- (2) 6mm Flat Washers
- (2) 6mm Flange Nuts



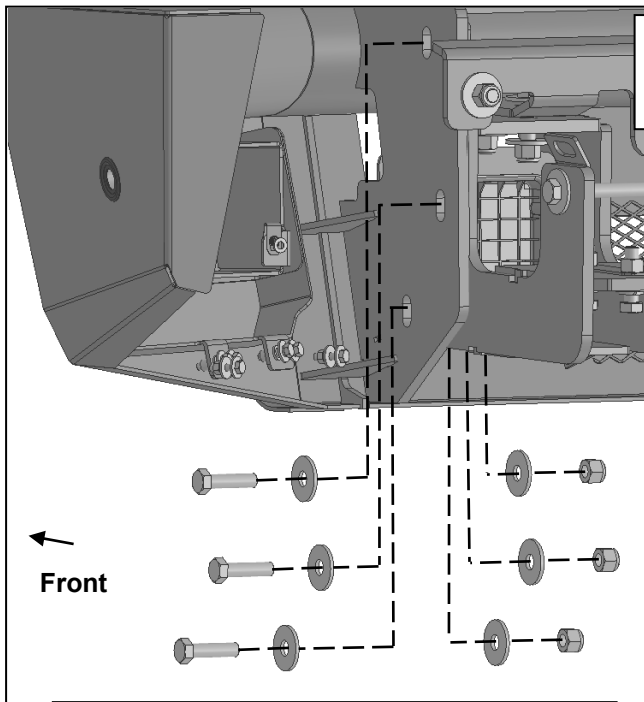
(Fig 23) Models equipped with ACC, attach sensor to back of Relocation Bracket

- (2) 6mm x 25mm Hex Bolts
- (4) 6mm Flat Washers
- (2) 6mm Lock Washers
- (2) 6mm Hex Nuts



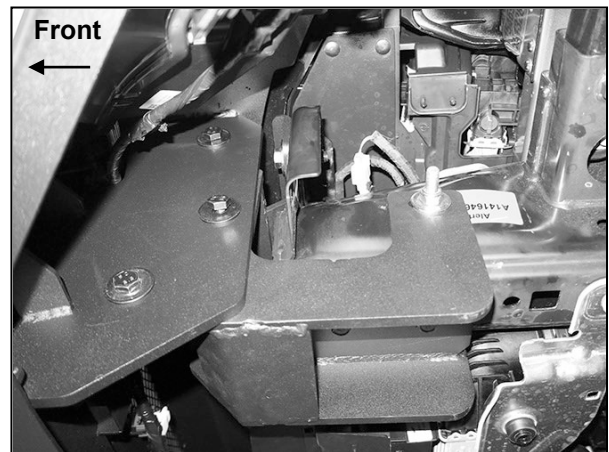
(Fig 24) Models with ACC, attach Bracket with ACC sensor to tab on back of Bumper

**WARNING!** Do not crawl under bumper unless it is properly supported on blocks or stands or the bumper may fall.



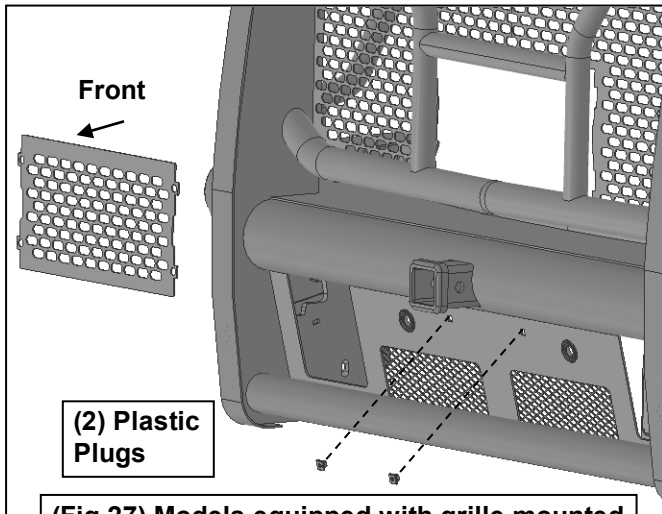
(Fig 25) Attach Bumper to Frame Mounting Bracket (driver/left side illustrated)

- (3) 12mm x 45mm Hex Bolts
- (6) 12mm Flat Washers
- (3) 12mm Nylon Lock Nuts

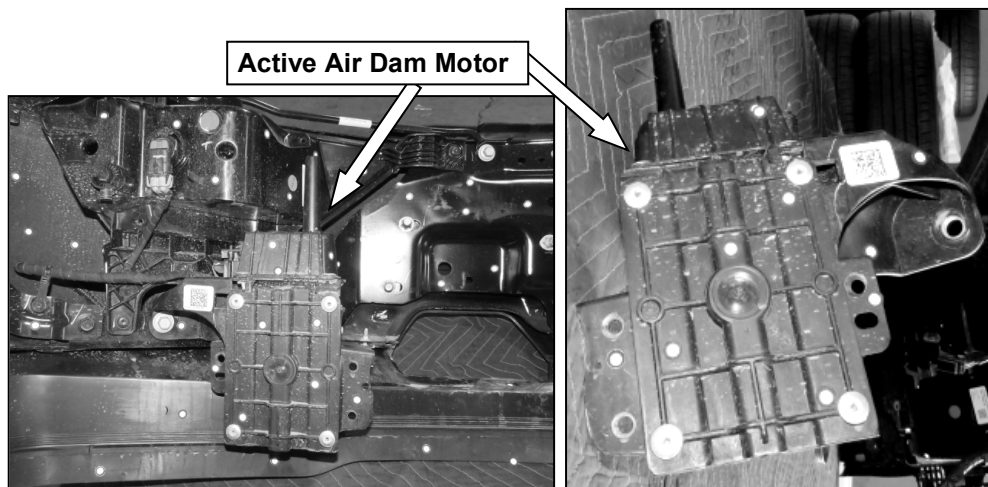


(Fig 26) Driver/left side of Bumper attached to Bracket (pictured from below)

**STEELCRAFT HD REPLACEMENT FRONT BUMPER  
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**(Fig 27) Models equipped with grille mounted camera, remove center screen. Reuse factory screws to attach license plate to Plastic Plugs**



**(Fig 28) FINAL NOTE: This is not a sensor. This air dam motor does not get re-installed.**